

Work Order ID 71269

Friday, June 24, 2011 3:42:55 PM

Page 1

Item ID: D3953-15

Accept

Revision ID:

Item Name: Gas Spring Bracket

Start Date: 6/24/2011 Start Qty: 12.00

Required Date: 6/30/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date: 1106-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3953

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

111-6-27

18

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1131-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71269

Friday, June 24, 2011 3:42:55 PM

Page 2

Item ID: D3953-15

Accept

Setup Start

Revision ID:

Stop

Item Name: Gas Spring Bracket

Start Date: 6/24/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulace/27

418

130

0.00



Small Fab

Memo

0.00

Small Fab

1- CHAMFER HOLE AS PER DWG

2- DEBURR IF NECESSARY

Sulace/27 18

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulace/27

418

W/O:		WORK ORDER CHANGES					
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Work Order ID 71269

Friday, June 24, 2011 3:42:56 PM



Page 3

Item ID: D3953-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Bracket

Start Date: 6/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 096

0.00



Packaging

Memo

0.00

Packaging

04/28 (18)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/16/28 JF11-06-28
(18)

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NOTE: Date & initial all entries

Picklist Print

Friday, June 24, 2011 3:43:01 PM

Page 1

Work Order ID: 71269



Parent Item: D3953-15



Parent Item Name: Gas Spring Bracket

Start Date: 6/24/2011



Required Date: 6/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
DD 10.03.02 verified by:EC

IPP Rev:B as per dwg revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	103.0000	0.0197 	0.248842	5		
KB11-6-07													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT020			103						
				117494			103			117494		(18)	

W/O:		WORK ORDER CHANGES					
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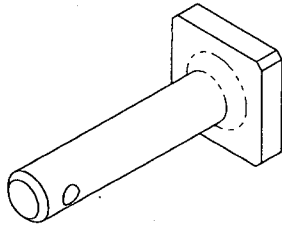
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING₂

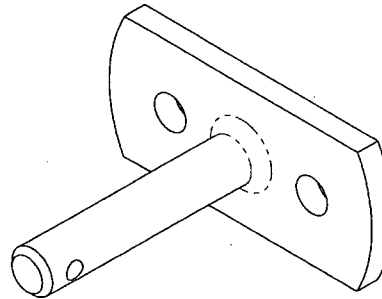
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71269
2011-06-27



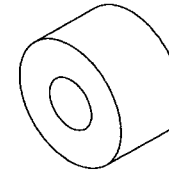
D3953-1 GAS SPRING BRACKET
(FULL LID)



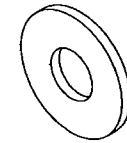
D3953-3 GAS SPRING STUD, LID



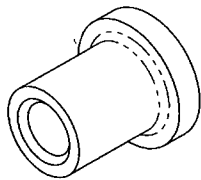
D3953-5 GAS SPRING STUD, BASE



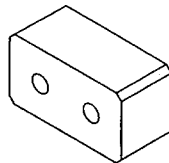
D3953-7 GAS SPRING SPACER



D3953-9 GAS SPRING WASHER



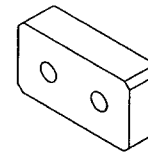
D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)

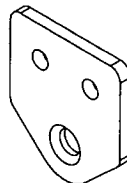


D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
2010-02-26



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 1 & 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); E SYMM WAS E SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1 DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

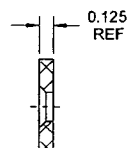
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

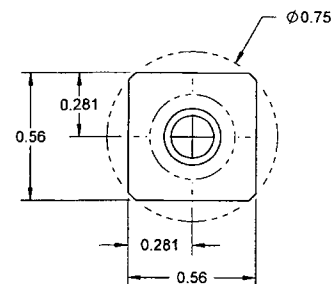
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

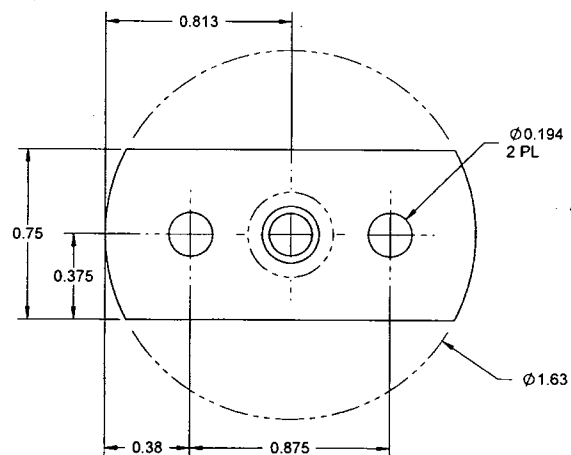
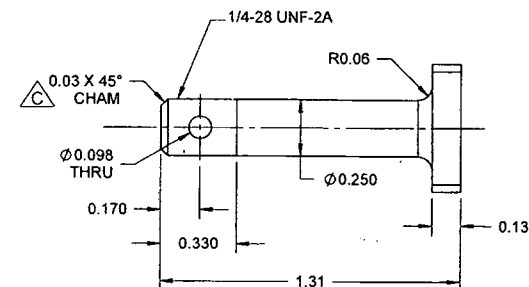
NOTE: Date & initial all entries



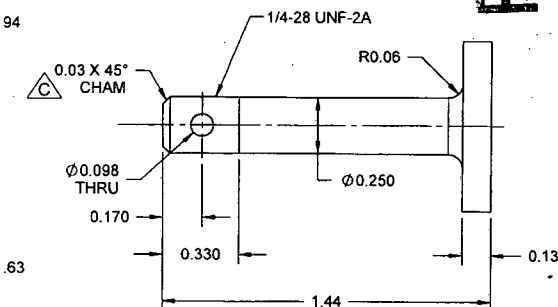
SECTION A-A_{C7-2}



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



DECLASSIFIED
2010-02-26

1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AIS1 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
 -3: 0.03 lbs
 -5: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS SCALE NTS	REV. C SHEET 2 OF 4 DATE 10.01.29
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
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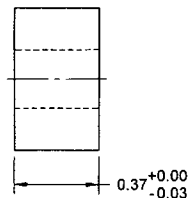
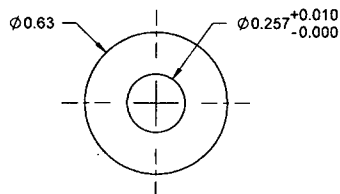
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

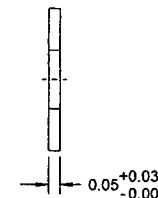
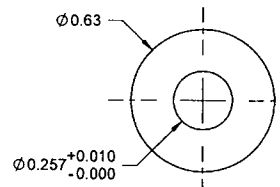
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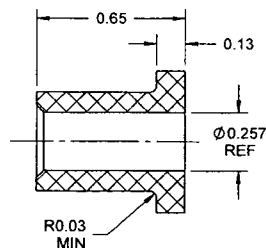
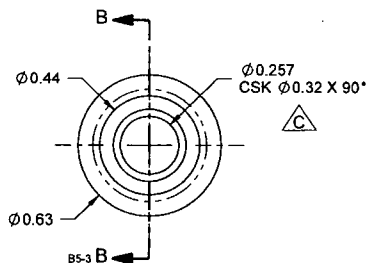
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

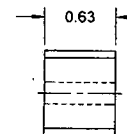
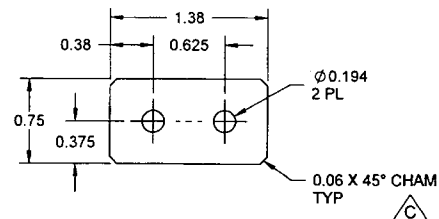


D3953-9 GAS SPRING WASHER



SECTION B-B B7-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS NTS	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASE
2010-02-26

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
 -17: 0.10 lbs
 -19: 0.07 lbs
 -21: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. <i>[Blank]</i>
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 4 OF <i>[Blank]</i>
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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